

Work Order ID 151873

151873

Thursday, October 13, 2016 11:25:58 AM

Page 1

ship Oct 17
or
ASAP.

Item ID: D145-762-153 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Replacement Run-on Landing Wearplates for Standard Skidtubes, Fit LH or RH
Start Date: 10/13/2016 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 10/17/2016 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: em Date: 10/10/13 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D117-762	E	DAS 6 9-89	OCT 17 2016			DAS 21 9-89	OCT 17 2016		
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00				DAS 27 9-89			
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D145-762-153 CHG004								
						OCT 17 2016			
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00				DAS 6 9-89	DAS 28 9-89	OCT 17 2016	
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00				DAS 27 9-89			
Quality Control									
						OCT 17 2016			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Thursday, October 13, 2016 11:25:58 AM

Page 2

DAS
21
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					

Picklist Print

Thursday, October 13, 2016 11:25:58 AM

Page 1

Work Order ID: 151873

151873

Parent Item: D145-762-153

D145-762-153

Parent Item Name: Replacement Run-on Landing Wearplates for Standard Skid tubes, Fit LH or RH

Start Date: 10/13/2016

Required Date: 10/17/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.04.24 NEW ISSUE DD VERF:JLM IPP
REV:B 13.11.14 AS PER IIN REV.C DD VERF:JLM IPP REV:C
14.11.24 as per ecn14-654/chg003 DD VERF:JLM IPP REV:D 15.06.11 IIN
REV.D DD VERF:JLM IPP REV:E 16.02.05 IIN REV.E
(ecn16-514) DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C43A *AN4C43A* BOLT		Purchased	No				Each	72.0000	4	8		OCT 17 2016	DAS 6 28 9-89 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST341				72					
				m132070				72					
D4769-041 *D4769-041* Wearplate Assembly		Manufactured	No			110	Each	4.0000	1	2		OCT 17 2016	DAS 6 28 9-89 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				4					
				133489				1					
				139036				3					
D4773-041 *D4773-041* Wearplate Assembly		Manufactured	No			110	Each	2.0000	1	2		OCT 17 2016	DAS 6 28 9-89 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st612				2					
				144734				2					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

Thursday, October 13, 2016 11:25:58 AM

Page 2

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Parent Item: D145-762-153

D145-762-153

Parent Item Name: Replacement Run-on Landing Wearplates for Standard Skid tubes, Fit LH or RH

Start Date: 10/13/2016

Required Date: 10/17/2016

Start Qty: 2.00

Required Qty: 2.00

D4771-041

Manufactured No

110

Each

2.0000

1

2

D4771-041

Wearplate Assembly

**

DAS 6 28
9-89 9-89

OCT 17 2016

Location

Loc Qty

Loc Code

ST604

2

144733

2

D4764-1

Manufactured No

110

Each

76.0000

12

24

D4764-1

Bushing

**

DAS 6 28
9-89 9-89

OCT 17 2016

Location

Loc Qty

Loc Code

ST124

76

145644

26

150201

50

AN4C42A

Purchased No

110

Each

24.0000

2

4

AN4C42A

Bolt

**

DAS 6 28
9-89 9-89

OCT 17 2016

Location

Loc Qty

Loc Code

ST341

24

M131947

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Thursday, October 13, 2016 11:25:58 AM

Page 3

Work Order ID: 151873***151873*****Parent Item:** D145-762-153***D145-762-153*****Parent Item Name:** Replacement Run-on Landing Wearplates for Standard Skid tubes, Fit LH or RH**Start Date:** 10/13/2016**Required Date:** 10/17/2016**Start Qty:** 2.00**Required Qty:** 2.00

MS21043-4

Purchased

No

110

Each

894.0000

6

12

MS21043-4******

Nut

OCT 17 2016

DAS

6
9-89DAS
28
9-89DAS
27
9-89LocationLoc QtyLoc Code

FG	40	
104603	40	
GA	17	
m132803	17	
OVER007	500	
m135600	500	
ST302	337	
m135407	37	
m135530	300	

12

Thursday, October 13, 2016 11:25:58 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

5.2 D145-762-013/-113 Skidtube Parts List

Item	Qty -013	Qty -043	Qty -053	Qty -113	Qty -153	Part Number	Description
	X					D145-762-013	SKIDTUBE WITH STD WEARPLATES
	1	X		1		D145-762-043	REPLACEMENT STD SKIDTUBE
	1		X			D145-762-053	REPLACEMENT WEARPLATES (STD SKIDTUBES)
				X		D145-762-113	SKIDTUBE WITH TRAINING WEARPLATES
				1	X	D145-762-153	REPLACEMENT TRAINING WEARPLATES (STD SKIDTUBE)
101		1				D4680-041	SKIDTUBE ASSEMBLY
102	2			2		**L321M1024101 OR **B321M1026101	SKID SHOE (REF ONLY)
103	8			8		**BRSP96/25-SK-WS-1 TEILIG OR **BRSP98/25-SK-WS-1 TEILIG OR **01618266098	CLAMP (REF ONLY)
104	8			8		**N/A	OEM BOLT (REF ONLY)
105	8			8		**N/A	OEM LOCKING WASHER (REF ONLY)
106	8			8		**N/A	OEM WASHER (REF ONLY)
110A		1				*D2965	CAP
110B		1				*D2965-3	CAP
111		4				***AELS-1032-225	INSERT
112		2				*AN3C5A	BOLT
113		2				*NAS1149C0332R	WASHER (OR AN960C10L)
114		2				*AN526C1032	SCREW
120A			1			D4682-041	WEARPLATE
120B			1			D4682-043	WEARPLATE
120C			1			D4682-7	WEARPLATE
121A					1	D4769-041	WEARPLATE
121B					1	D4773-041	WEARPLATE
121C					1	D4771-041	WEARPLATE
122			12		12	D4764-1	BUSHING
123			2		2	AN4C42A	BOLT
124			4		4	AN4C43A	BOLT
125			6		6	MS21043-4	NUT
130		3				*AELS-1032-130	INSERT
131		3				*AN3C4A	BOLT
132		3				*NAS1149C0332R	WASHER (AN960C10L)
150	2			2		AN6C52A	BOLT
151	2			2		D5300-1	GHL BUSHING
152	2			2		D5301-1	GHL PLUG
153	2			2		MS21043-6	NUT

* PART IS INCLUDED WITH D4680-041 STD SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE